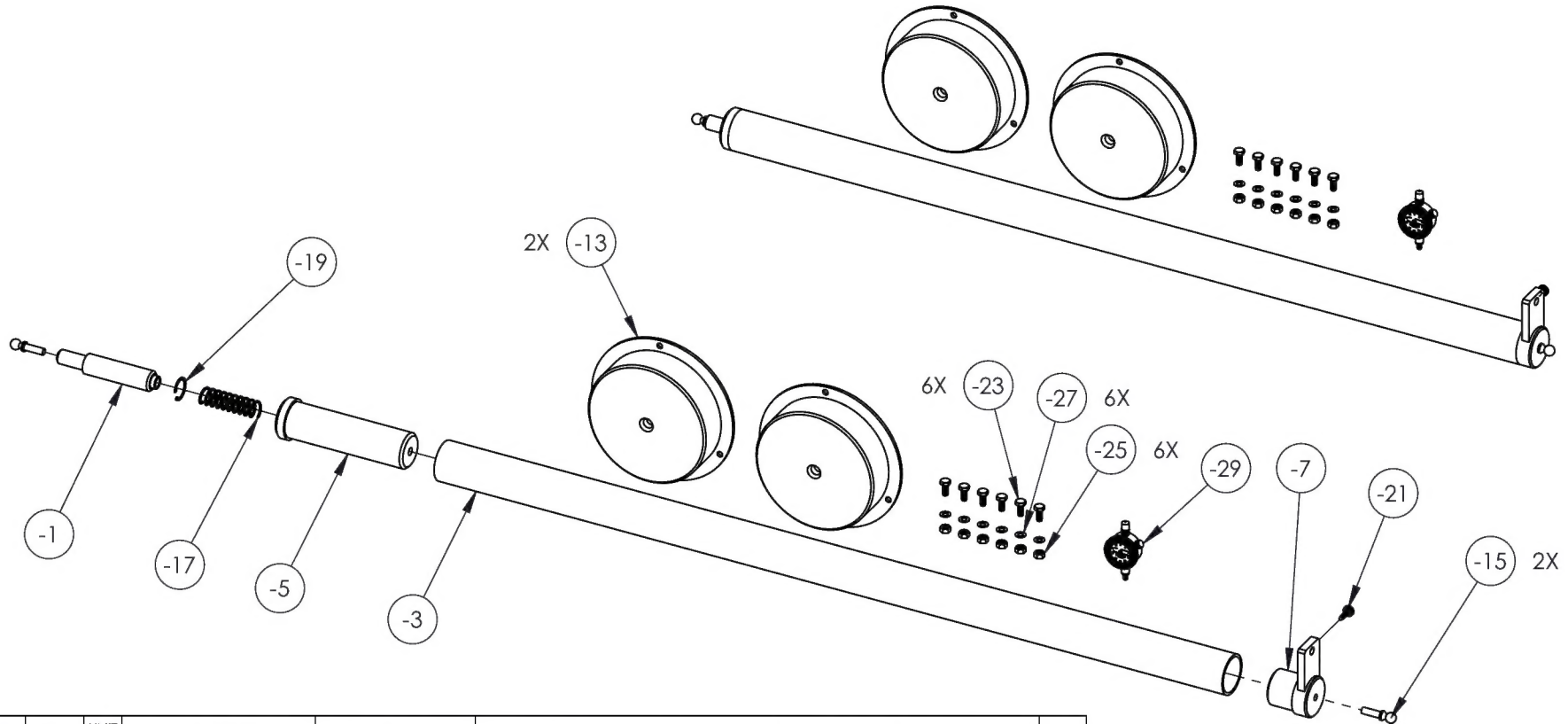


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D MAT'L WAS 4140 IS 4140 Q&T/4142 Q&T. REMOVED HEAT TREAT. -3 CH'D FINISH WAS ANODIZE GREY IS CLEAR ANODIZE. DELETED ENGRAVE NOTE. -5 & -9 CH'D DIM WAS LIMITS Ø1.7618-1.7624 IS LIMITS Ø1.7610-1.7615.	1/7/2015	DPD	JAG

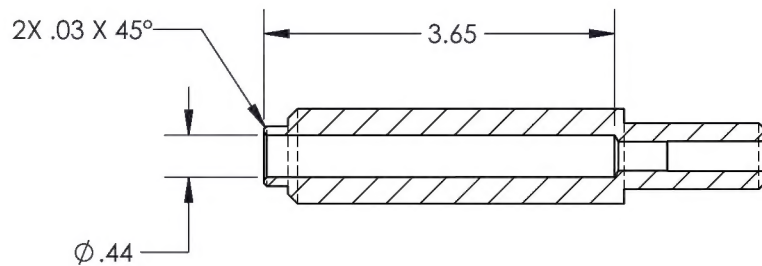
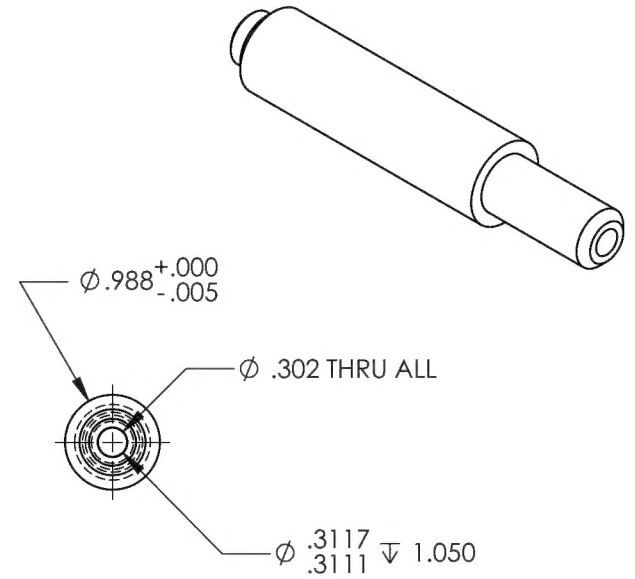
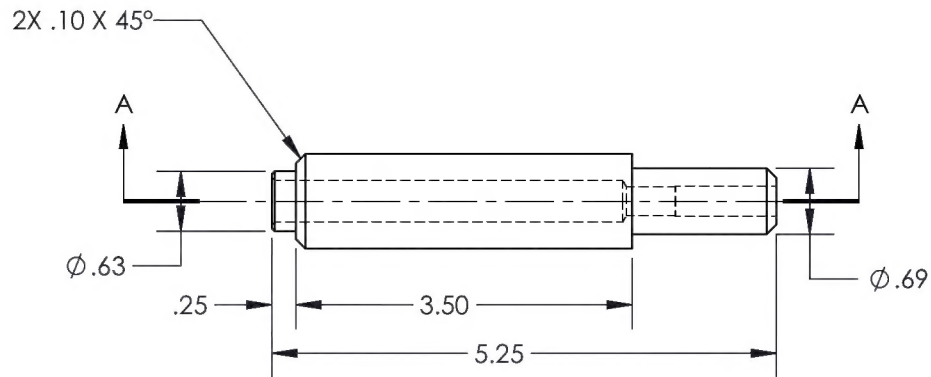


ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	PLUNGER	4140 Q&T/4142 Q&T		2
		-3	1	TUBE	6061		3
		-5	1	INSERT	1018		4
X		-7	1	WELDMENT			5
1		-9		INSERT 2	1018		6
1		-11		PLATE	1018		7
		-13	2	ADAPTER	4140/4142		8
	B/O	-15	2	CONSTRUCTION BALL	STEEL	Ø1/2 X .94, 6-32 X 5/16 (CARR LANE #CL-5-SCB)	1
	B/O	-17	1	SPRING	STEEL	Ø.688 I.D. X .850 O.D. X Ø.081 WIRE X 2.75, 15 LBS/IN (CENTURY SPRING #72243)	1
	B/O	-19	1	INTERNAL RETAINING RING	STEEL	Ø1 BORE X .042 (MCMASTER-CARR #98409A211)	1
	B/O	-21	1	THUMB SCREW	S.S.	10-32 X 3/4 (CARR LANE #CL-23207)	1
	B/O	-23	6	BOLT	STEEL	1/4-28 AN4-5	1
	B/O	-25	6	NUT	STEEL	1/4-28 MS35650-3252	1
	B/O	-27	6	WASHER	STEEL	1/4 AN960-416	1
	B/O	-29	1	DIAL INDICATOR		STARRETT AMI-81-231J-W/FBP	1
ASSY -7							

TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1	DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:8 DATE 7/18/2012	USED ON MODEL BELL 412HP SHEET 1 OF 8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	•1 CH'D MAT'L WAS 4140 IS 4140 Q&T/4142 Q&T. REMOVED HEAT TREAT.	1/7/2015	DPD	JAG



SECTION A-A

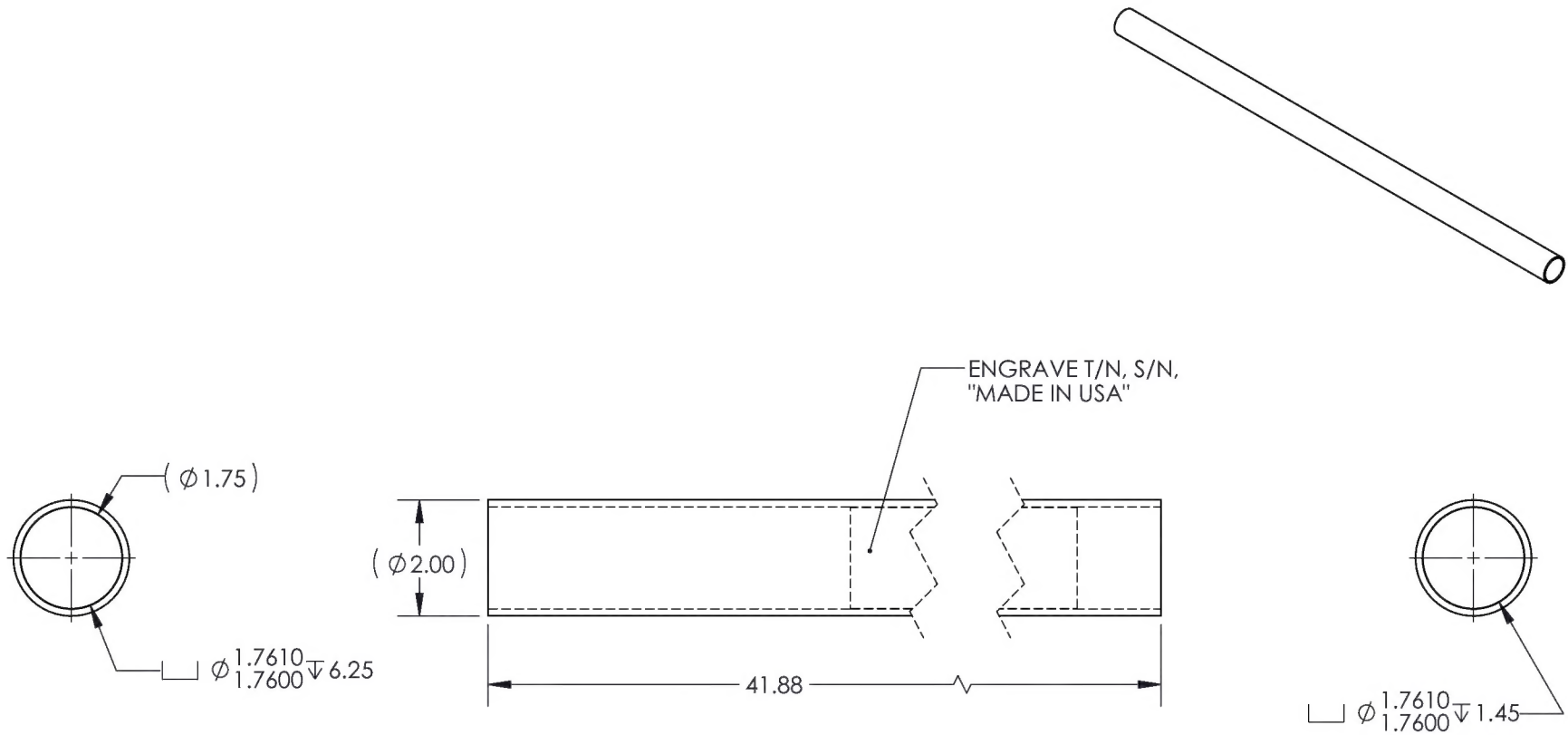
(-1)

PLUNGER

DART AEROSPACE	
TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125-1	REV 1
MAT'L 4140 Q&T/4142 Q&T	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 412HP
SCALE 1:2	DATE 7/18/2012
SHEET 2 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	-3 CH'D FINISH WAS ANODIZE GREY IS CLEAR ANODIZE. DELETED ENGRAVE NOTE.	1/7/2015	DPD	JAG



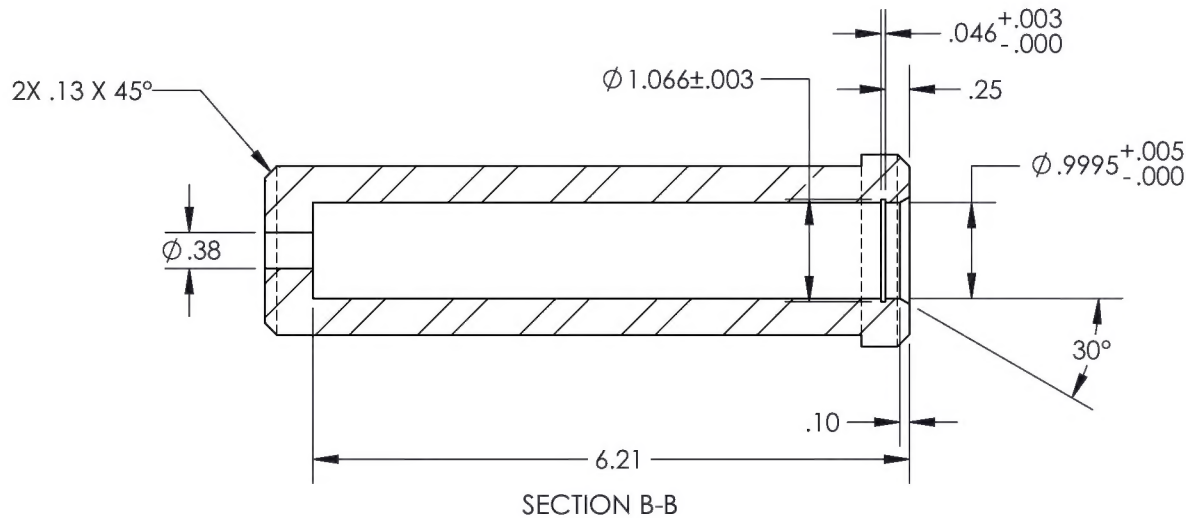
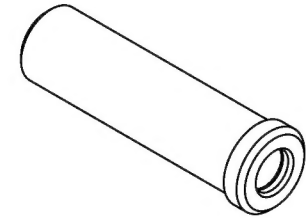
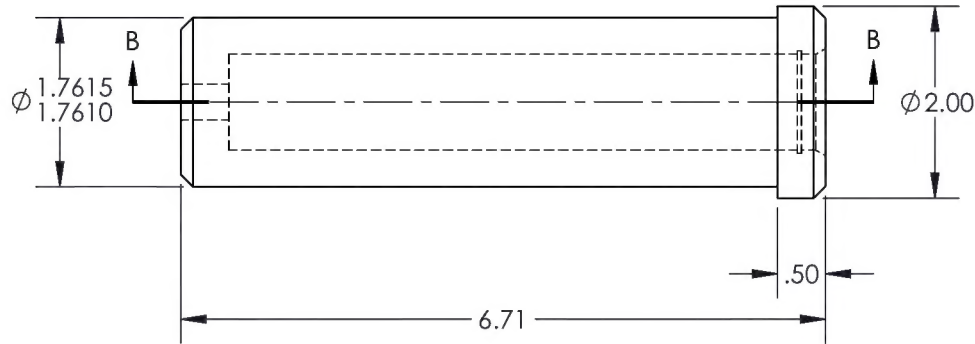
(-3)

TUBE

DART AEROSPACE	
TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125-3	REV 1
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 412HP
SCALE 1:3	DATE 7/18/2012
SHEET 3 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	-5 CH'D DIM WAS LIMITS Ø1.7618-1.7624 IS LIMITS Ø1.7610-1.7615.	1/7/2015	DPD	JAG



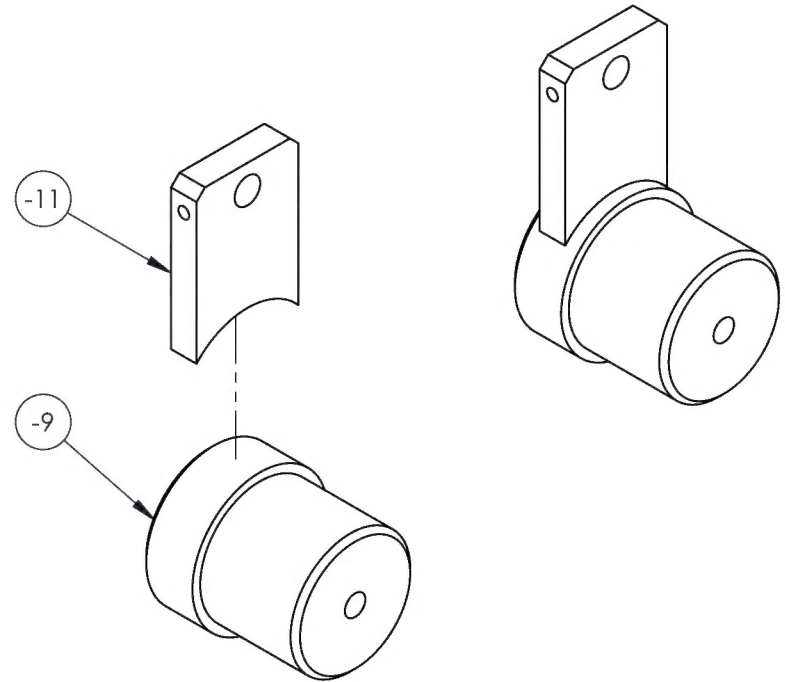
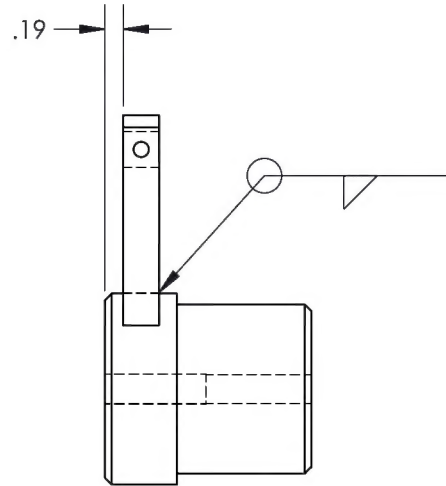
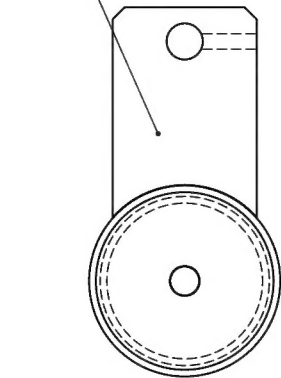
(-5)
INSERT

DART AEROSPACE	
TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125-5	REV 1
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 412HP
SCALE 1:2	DATE 7/18/2012
SHEET 4 OF 8	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

ENGRAVE "RB T101743-107
RB T101743-101
OR
RB T101743-125
TOOL SET"



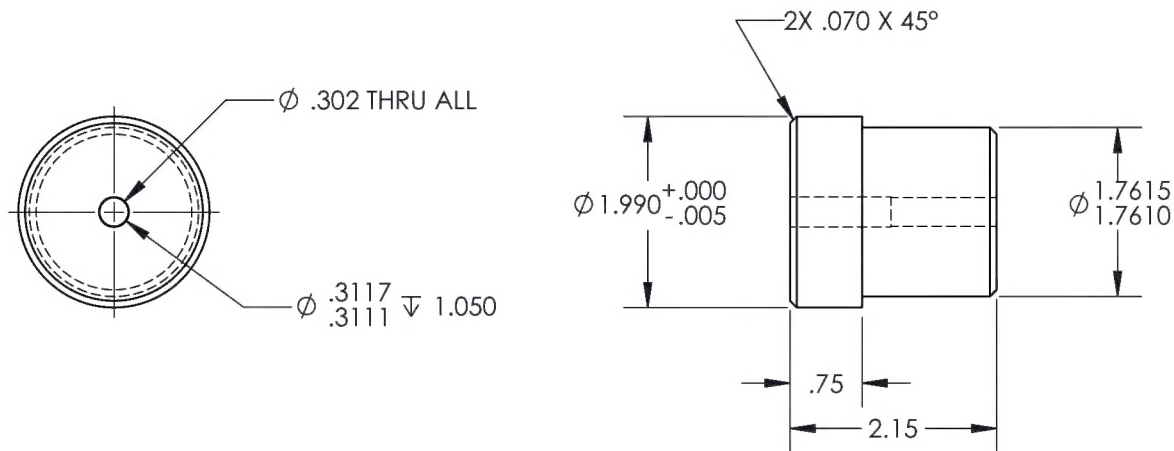
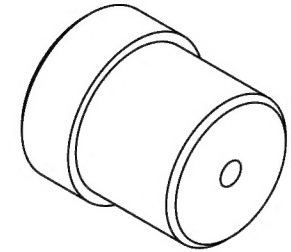
(-7)

WELDMENT

DART AEROSPACE	
TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125-7	REV 1
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC QQ-P-416F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 412HP
SCALE 1:2	DATE 7/18/2012
SHEET 5 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0233	-9 CH'D DIM WAS LIMITS Ø1.7618-1.7624 IS LIMITS Ø1.7610-1.7615.	1/8/2015	DPD	JAG

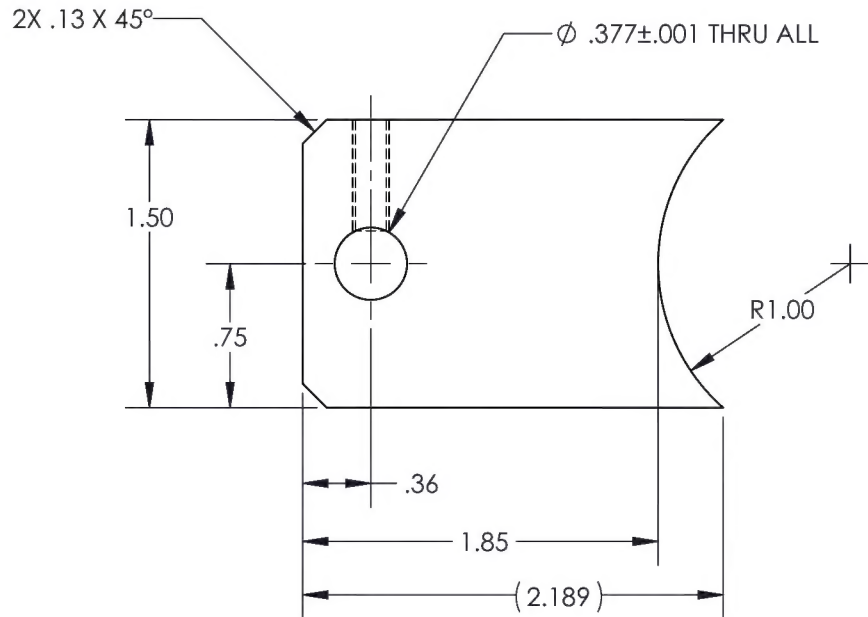
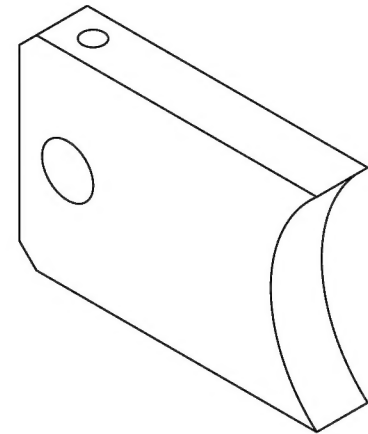
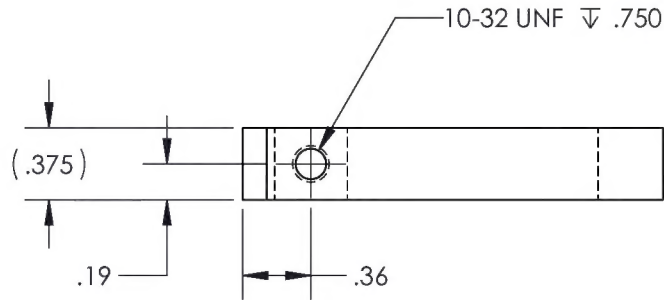


(-9)
INSERT 2

DART AEROSPACE	
TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125-9	REV 1
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH SEE -7 WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 412HP
SCALE 1:2	DATE 7/18/2012
SHEET 6 OF 8	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(11)

PLATE

DART AEROSPACE	
TITLE D/S ALIGNMENT TOOL	
DWG NO. RB T101743-125-11	REV 1
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH SEE -7 WELDMENT
.X ± .1	ANGLES ± 5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 412HP
SCALE 1:1	DATE 7/18/2012
SHEET 7 OF 8	

